

[illegible]

Page 1

Accept

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

2. Once the problem is identified, the next step is to define the objectives and goals of the project. This helps to clarify what needs to be achieved and provides a clear direction for the work.

3. The third step is to develop a plan or strategy to address the problem. This involves breaking down the problem into smaller, manageable tasks and determining the resources needed to complete them.

4. The fourth step is to implement the plan. This involves putting the strategy into action and monitoring progress to ensure that the objectives are being met.

5. The final step is to evaluate the results of the project. This involves assessing the outcomes against the objectives and identifying any areas for improvement or further action.

Setup Start[illegible]

Stop

[REDACTED]

[illegible]**Cust Item ID:**[illegible]

Customer:

Reference:

Run Start

[illegible]

Date: 11-04-11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

[illegible]

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 68270

Monday, April 11, 2011 11:12:17 AM



Page 2

Item ID: D4151-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Fwd Hardpoint Assembly, Lower

Start Date: 4/11/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/13

ME

11-04/3

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

Monday, April 11, 2011 11:12:24 AM

Page 1

Work Order ID: 68270

Parent Item: D4151-041

Parent Item Name: Basket Fwd Hardpoint Assembly, Lower

Start Date: 4/11/2011




Required Date: 4/15/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC
IPP Rev:B 10.07.22 as per revB DD verf:JLM
11.01.21 as per dwg revC DD verf:JLM

IPP Rev:C

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|-----------------------------------------------------------------------------------------------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|-----------------|-------------|--------------|---------------|----------------|--------|
| D4151-1  Lower Hardpoint Plate | | Manufactured | No | | | 100 | Each | 1.0000 | 2 | 4 | | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | ST134 | | 1 | B68271 | | 3 | | | | (2) |
| | | | | | 65758 | 1 | | | 1 | | | | |
| D4151-5  Fwd Basket Instl Stud | | Manufactured | No | | | 100 | Each | 2.0000 | 1 | 2 | | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | GA | | 2 | | | | | | | |
| | | | | | 67713 | 2 | | | 2 | | | | |
| AN4C13A  BOLT | | Purchased | No | | | 100 | Each | 72.0000 | 2 | 4 | | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | ST353 | | 60 | | | | | | | |
| | | | | | 117366 | 60 | | | 4 | | | | |
| | | | | ST357 | | 12 | | | | | | | |
| | | | | | 114492 | 4 | | | | | | | |
| | | | | | 116914 | 8 | | | | | | | |

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|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Picklist Print

Monday, April 11, 2011 11:12:24 AM

Page 2

Work Order ID: 68270

Parent Item: D4151-041

Parent Item Name: Basket Fwd Hardpoint Assembly, Lower

Start Date: 4/11/2011

Required Date: 4/15/2011

Start Qty: 2.00

Required Qty: 2.00

MS21043-4

Purchased

No

100

Each

661.0000

2

4



SB 11/04/13 (2)

Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

621

114523

3

116188

318

116549

300

4

NAS1149C0432R

Purchased

No

100

Each

6,590.000

4

8



SB 11/04/13 (2)

Washer

Location

Loc Qty

Loc Code

ST297

6590

116900

1590

117291

5000

8

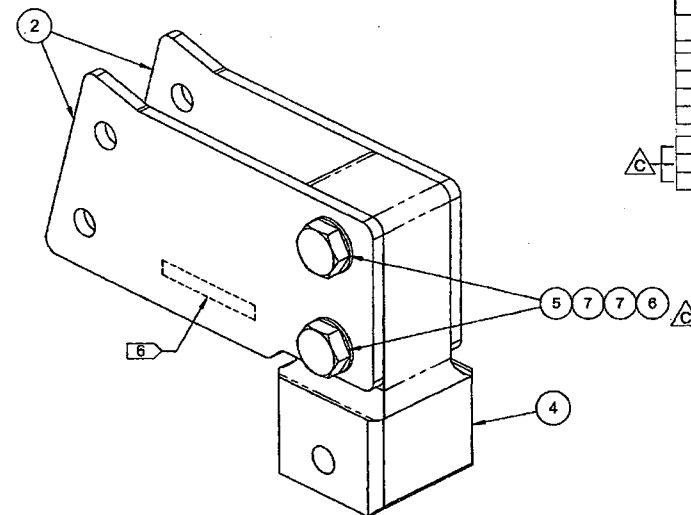
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

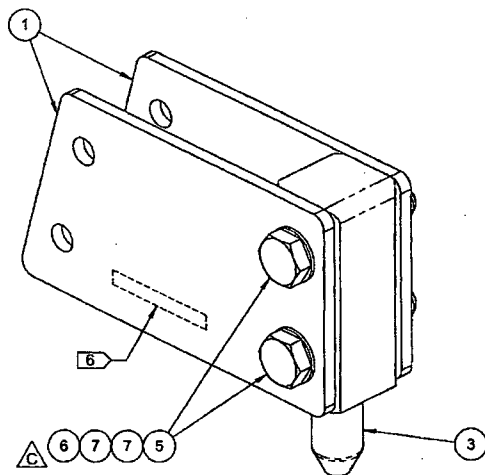
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



D4151-043 BASKET FWD HARDPOINT ASSY (UPPER)



D4151-041 BASKET FWD HARDPOINT ASSY (LOWER)

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4151-04X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT:
 - D4151-041 = 0.88 lbs
 - D4151-043 = 1.17 lbs

| ITEM | QTY -041 | QTY -043 | P/N | DESCRIPTION |
|------|-------------|-------------|---------------|-----------------------------------|
| | X | | D4151-041 | BASKET FWD HARDPOINT ASSY (LOWER) |
| | | X | D4151-043 | BASKET FWD HARDPOINT ASSY (UPPER) |
| 1 | 2 | | D4151-1 | LOWER HARDPOINT PLATE |
| 2 | | 2 | D4151-3 | UPPER HARDPOINT PLATE |
| 3 | 1 | | D4151-5 | FWD BASKET INSTL STUD (LOWER) |
| 4 | | 1 | D4151-7 | FWD EYEBOLT RECEIVER (UPPER) |
| 5 | 2 | 2 | AN4C13A | BOLT |
| 6 | 2 | 2 | MS21043-4 | NUT |
| 7 | 4 | 4 | NAS1149C0432R | WASHER |

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 68270

11-04-11

RELEASED
2011-01-18

| | | | |
|------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----|----------|
| C | AN4 HARDWARE WAS AN3 (B6-1, C3-1 & D3-1); ϕ 0.252 WAS ϕ 0.191 (C5-2, D1-2); TIGHTENED TOL ON 1.000 DIM (C5-2, D1-2, C7-3, C3-3); ϕ 0.250 WAS ϕ 0.191 (C6-3, B4-3); 1.83 WAS 1.75 (C1-2), 2.84 WAS 2.78 (B3-3) AND 1.88 WAS 1.80 (C1-3) TO PRESERVE 1.SED. REASON: SEE D407-797 DESIGN JOURNAL. | MB | 10.12.14 |
| B | ADDED D4151-5/-7 (SHT 3); D4151-5 WAS D3911-1 (ZN B6-1 & D3-1); D4151-7 WAS D3911-3 (ZN C4-1 & D3-1) ITEMS #5, #6 & 7 REPLACE MS20615-4M20 (ZN C5-1, D3-1 & B6-1); ϕ 0.191 2 PL REPLACES ϕ 0.129 3 PL (ZN C5-2); ϕ 0.191 2 PL REPLACES ϕ 0.129 4 PL (ZN D1-2). REASON: SEE TR-D390-007-2 REV. B. | MB | 10.07.06 |
| A | NEW ISSUE | MB | 10.06.22 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | | | |
| DRAWN | | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 10.12.14 | | |

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4151** REV. C
SHEET 1 OF 3
TITLE **BASKET FWD HARDPOINT** SCALE NTS

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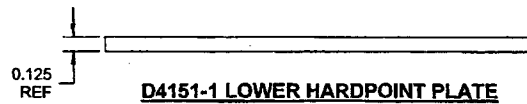
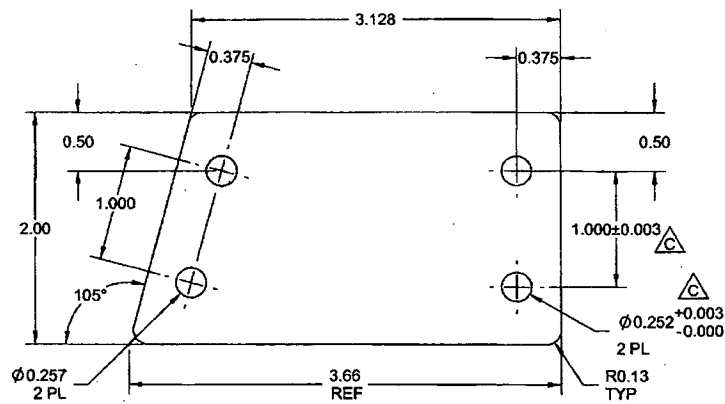
| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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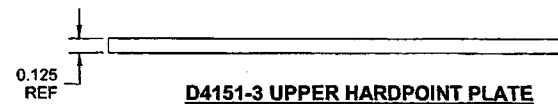
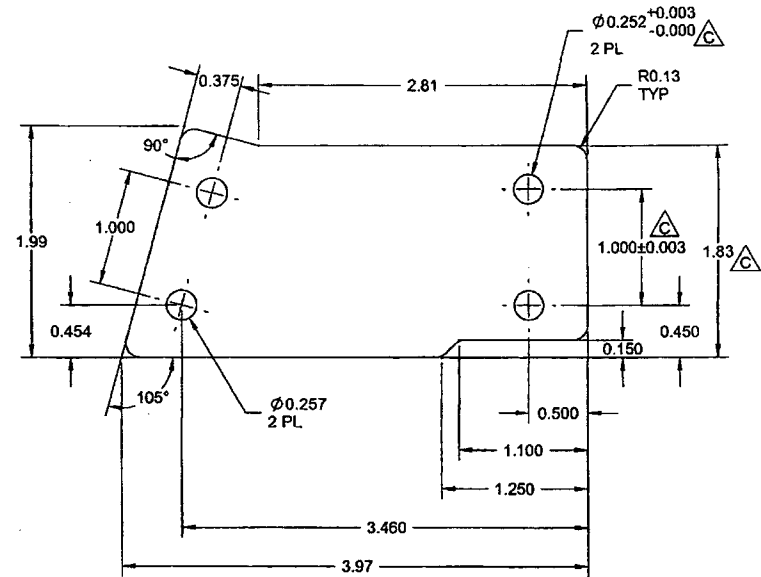
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NOTE: Date & initial all entries



D4151-1 LOWER HARDPOINT PLATE



D4151-3 UPPER HARDPOINT PLATE

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
- 7) WEIGHT:
- D4151-1 = 0.24 lbs
- D4151-3 = 0.23 lbs

w/b 68270

RELEASED
2011-01-18
MP

| | | |
|------------|-----------|-----------------------------------|
| DESIGN | | DART AEROSPACE LTD |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | <i>SC</i> | DRAWING NO. D4151 |
| MFG. APPR. | <i>MP</i> | REV. C |
| APPROVED | <i>MP</i> | SHEET 2 OF 3 |
| DE APPR. | <i>MP</i> | TITLE BASKET FWD HARDPOINT |
| DATE | 10.12.14 | SCALE NTS |

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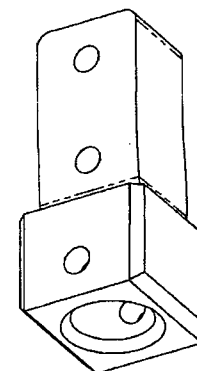
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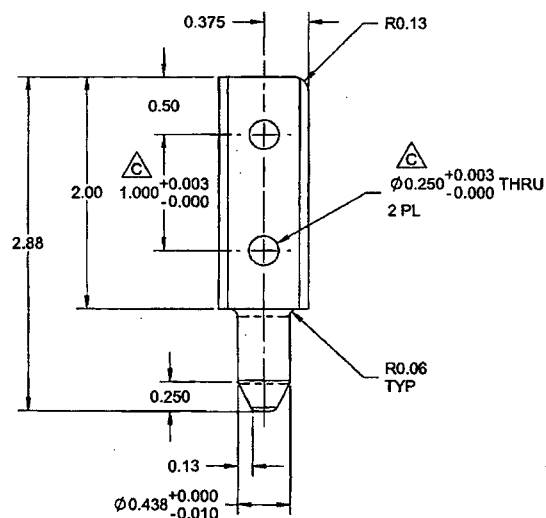
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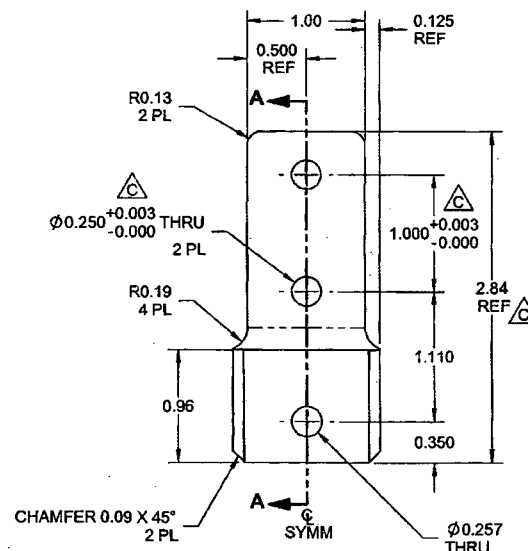
NOTE: Date & initial all entries



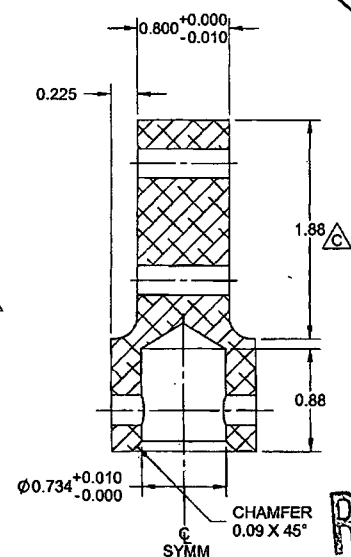
w/o 48270



D4151-5 FWD BASKET INSTL STUD (LOWER)



D4151-7 FWD EYEBOLT RECEIVER (UPPER)



SECTION A-A

RELEASED
2011-06-23
RELEASED

NOTES:

- NOTES**
- 1) MATERIAL -5: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303R OR M304R
-7: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303B OR M304B
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
 - 7) WEIGHT -5: 0.36 lbs
-7: 0.70 lbs

| | | | |
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| DESIGN | 15 | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4151 TITLE BASKET FWD HARDPOINT COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. NO REPRODUCTION WHATSOEVER IS NOT TO BE USED FOR ANY PURPOSES OR COPIES OR TRANSMISSIONS BY ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small> | REV. 0 |
| DRAWN | 15 | | SHEET 3 OF 3 |
| CHECKED | SC | | |
| MFG. APPR. | MD | | SCALE |
| APPROVED | | | NTS |
| DE APPR. | H | | |
| DATE | 10.12.14 | | |

| W/O: | | WORK ORDER CHANGES | | | | | | |
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